












Ship Oct 15

Dart Aerospace Ltd.

Date: Friday, 9/21/2007 1:18:51 PM  
User: Kim Johnston

## Process Sheet

|   |  |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services  | Drawing Name : GPS RECEIVER HOUSING        |
| Job Number : 34821  |  |
| Estimate Number : 12492   |  |
| P.O. Number : N/A   | Part Number : D35143                       |
| This Issue : 9/21/2007 S.O. No. : N/A   | Drawing Number : UNDER REVIEW D3514        |
| Prsht Rev. : NC   | Project Number : N/A                       |
| First Issue : 9/21/2007 Type : SMALL /MED FAB   | Drawing Revision : N/A A 10/09/24 E        |
| Previous Run : 33307  | Material : N/A                             |
| Written By : _____  | Due Date : 10/12/2007 Qty: 5 Um: Each      |
| Checked & Approved By : _____   |  |
| Comment : Est Rev:A New Issue 06-07-26 JLM  |  |
| Additional Product  |  |
| Job Number:    |  |
| Seq. #:   | Machine Or Operation: Description :        |
| 1.0   | M6061T6S040 6061-T6 .040 Sheet             |
|               |  |
| Comment: Qty.: 0.4812 sf(s)/Unit Total : 2.4061 sf(s)<br>6061-T6 .040 Sheet<br>(M6061T6S040)<br>Batch: M102723 HB 07-10-2   |  |
| 2.0   | WATER JET FLOW WATER JET                   |
|           |  |
| Comment: FLOW WATER JET<br>1-Cut as per Dwg D3514<br>Dwg Rev: A HB 07-10-2<br>Prog Rev: A<br>***Ensure Grain Direction is correct*****<br>2-Deburr if necessary HB 07-10-2        |  |
| 3.0   | QC2 INSPECT PARTS AS THEY COME OFF MACHINE |
|           |  |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE   |  |
| 4.0   | QC8 SECOND CHECK                           |
|   Counter |  |
| Comment: SECOND CHECK En 07/01/02 50  |  |
| 5.0   | SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1  |
|           |  |
| Comment: SMALL & MEDIUM FAB RESOURCE 1<br>Countersink as per Dwg D3514 MF 07-10-10  |  |

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 09/10/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Friday, 9/21/2007 1:18:52 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 34821

Part Number: D35143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*can't*  
*2/10/10* (5)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3514

*SB 07/10/10* (5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*En* *2/10/10* (5)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M-F* *07/10/10*

(5x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*MF* *07-10-11* (5)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*GA* *MF* *07-10-11*

(5)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)  
*2/07/10/10*

Job Completion



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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

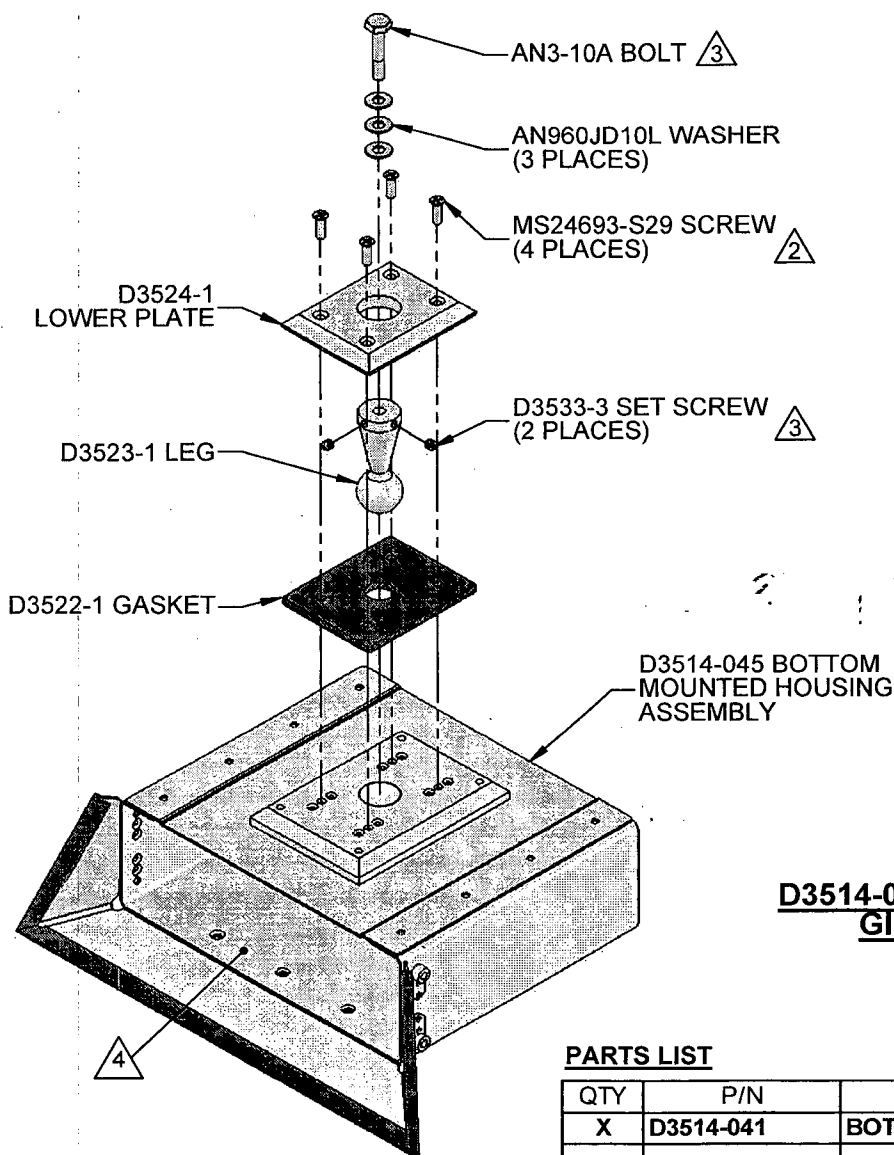
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                  |                               |   |                        |
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| CHECKED<br>LE    | APPROVED<br>[Signature]       | DRAWING NO.<br>D3514                              | REV. A<br>SHEET 1 OF 9 |
| DATE<br>07.06.18 | TITLE<br>GPS RECEIVER HOUSING |   | SCALE<br>1:3           |
| REV<br>A         | DATE<br>07.06.18              | DESCRIPTION<br>NEW ISSUE                          |                        |



RELEASED  
07.08.03

**D3514-041 BOTTOM MOUNTED  
GIMBAL ASSEMBLY**

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WITHOUT NOTICE  
WORK ORDER  
NO. \_\_\_\_\_

**NOTE:**

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

**PARTS LIST**

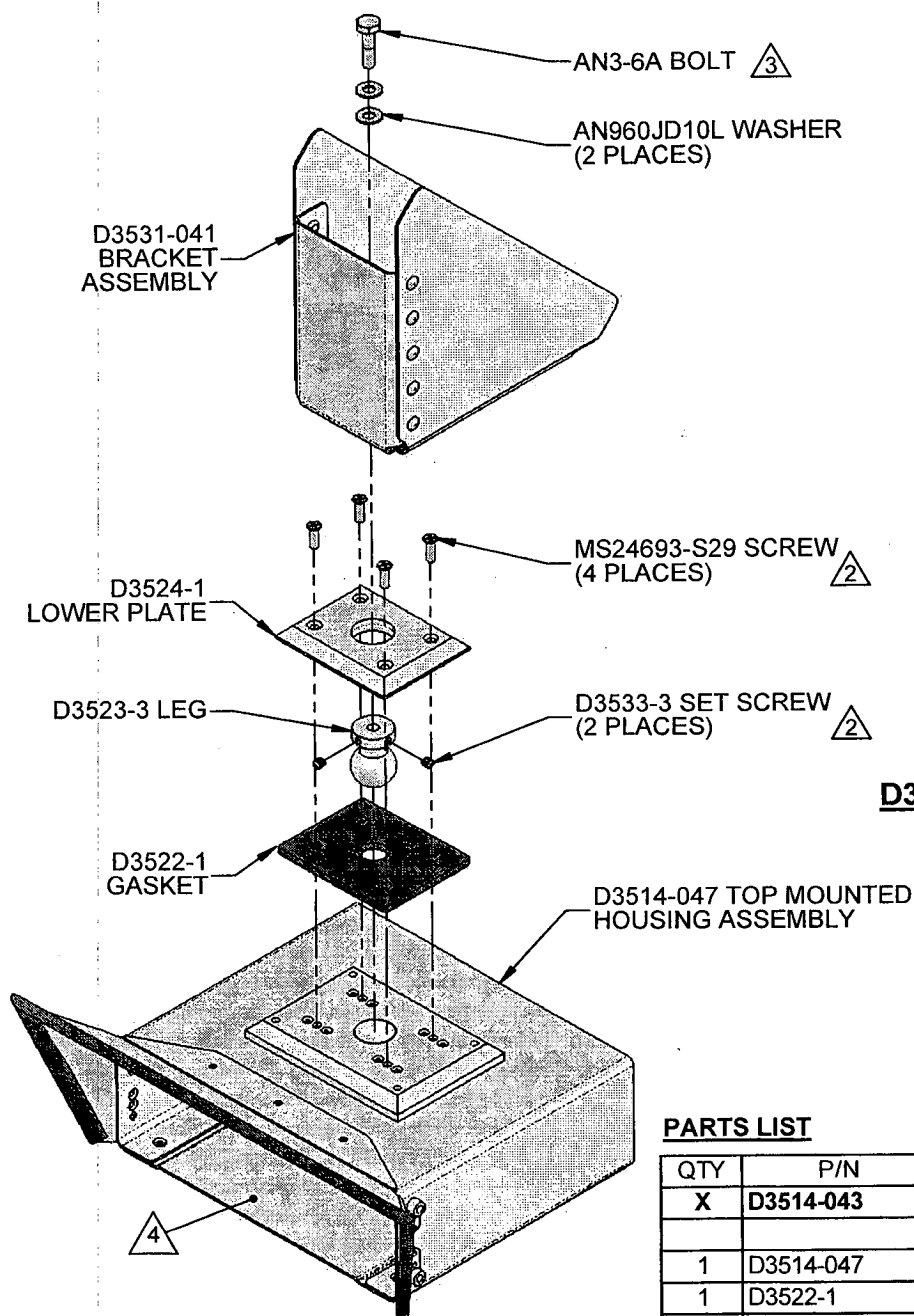
| QTY | P/N         | DESCRIPTION                     |
|-----|-------------|---------------------------------|
| X   | D3514-041   | BOTTOM MOUNTED GIMBAL ASSEMBLY  |
| 1   | D3514-045   | BOTTOM MOUNTED HOUSING ASSEMBLY |
| 1   | D3522-1     | GASKET                          |
| 1   | D3523-1     | LEG                             |
| 1   | D3524-1     | LOWER PLATE                     |
| 2   | D3533-3     | SET SCREW                       |
| 1   | AN3-10A     | BOLT                            |
| 3   | AN960JD10L  | WASHER                          |
| 4   | MS24693-S29 | SCREW                           |

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| DATE<br><b>07.06.18</b> |                                | TITLE<br><b>GPS RECEIVER HOUSING</b>                     | SCALE<br>1:3           |



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**D3514-043 TOP MOUNTED  
GIMBAL ASSEMBLY**

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NO. \_\_\_\_\_

**NOTE:**

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

**PARTS LIST**

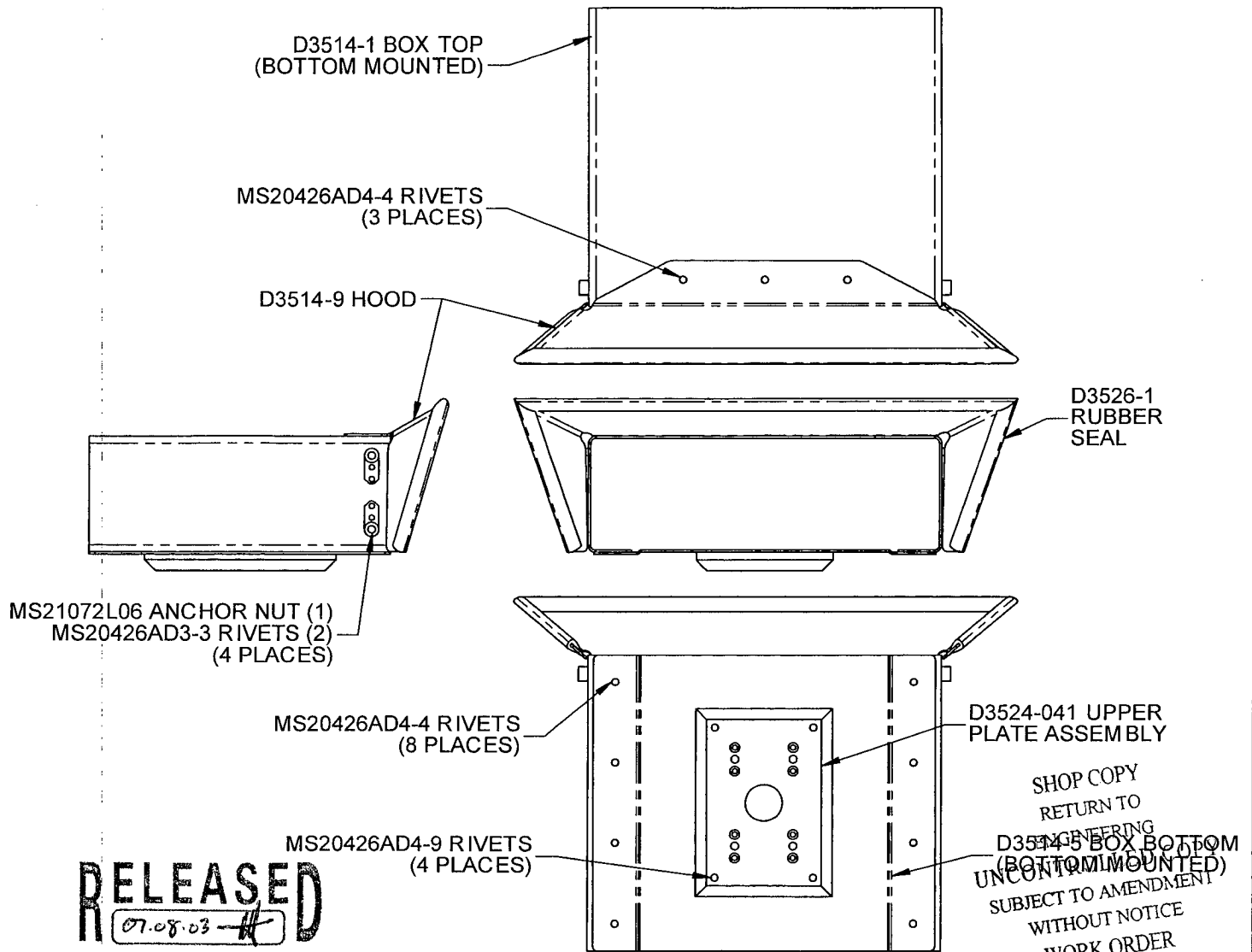
| QTY | P/N         | DESCRIPTION                  |
|-----|-------------|------------------------------|
| X   | D3514-043   | TOP MOUNTED GIMBAL ASSEMBLY  |
| 1   | D3514-047   | TOP MOUNTED HOUSING ASSEMBLY |
| 1   | D3522-1     | GASKET                       |
| 1   | D3523-3     | LEG                          |
| 1   | D3524-1     | LOWER PLATE                  |
| 1   | D3531-041   | BRACKET ASSEMBLY             |
| 2   | D3533-3     | SET SCREW                    |
| 1   | AN3-6A      | BOLT                         |
| 2   | AN960JD10L  | WASHER                       |
| 4   | MS24693-S29 | SCREW                        |

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| DATE<br>07.06.18 |                | TITLE<br>GPS RECEIVER HOUSING                     | SCALE<br>1:3           |



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D3514-5 BOX BOTTOM  
(BOTTOM MOUNTED)  
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### D3514-045 BOTTOM MOUNTED HOUSING ASSEMBLY

#### NOTES:

- 1) POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

#### PARTS LIST

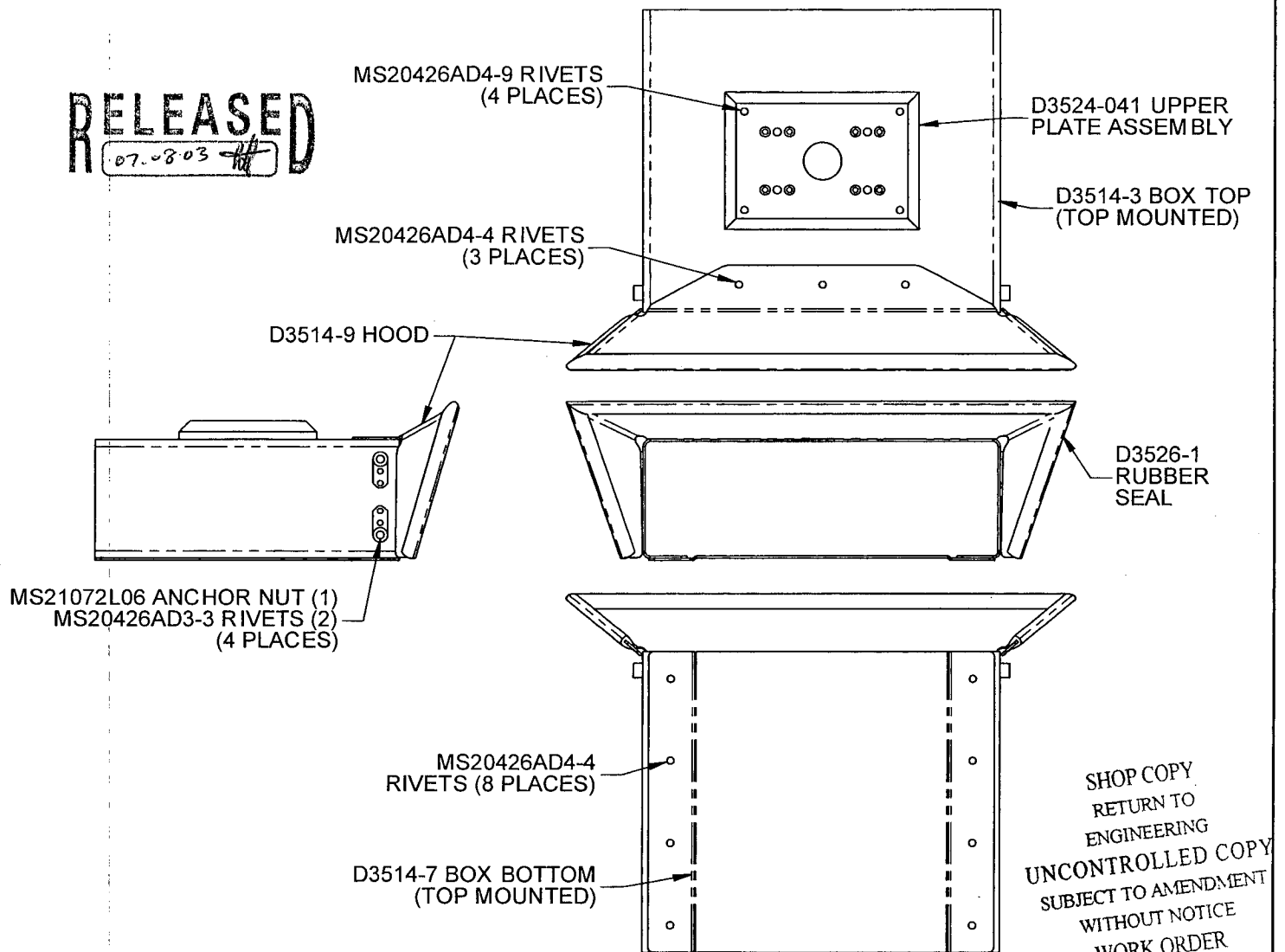
| QTY | P/N          | DESCRIPTION                     |
|-----|--------------|---------------------------------|
| X   | D3514-045    | BOTTOM MOUNTED HOUSING ASSEMBLY |
| 1   | D3514-1      | BOX TOP (BOTTOM MOUNTED)        |
| 1   | D3514-5      | BOX BOTTOM (BOTTOM MOUNTED)     |
| 1   | D3514-9      | HOOD                            |
| 1   | D3524-041    | UPPER PLATE ASSEMBLY            |
| 1   | D3526-1      | RUBBER SEAL                     |
| 8   | MS20426AD3-3 | RIVET                           |
| 11  | MS20426AD4-4 | RIVET                           |
| 4   | MS20426AD4-9 | RIVET                           |
| 4   | MS21072L06   | ANCHOR NUT                      |

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| DATE<br>07.06.18 |                         | TITLE<br>GPS RECEIVER HOUSING                     | SCALE<br>1:3           |



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**D3514-047 TOP MOUNTED  
HOUSING ASSEMBLY**

**NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

**PARTS LIST**

| QTY | P/N          | DESCRIPTION                  |
|-----|--------------|------------------------------|
| X   | D3514-047    | TOP MOUNTED HOUSING ASSEMBLY |
| 1   | D3514-3      | BOX TOP (TOP MOUNTED)        |
| 1   | D3514-7      | BOX BOTTOM (TOP MOUNTED)     |
| 1   | D3514-9      | HOOD                         |
| 1   | D3524-041    | UPPER PLATE ASSEMBLY         |
| 1   | D3526-1      | RUBBER SEAL                  |
| 8   | MS20426AD3-3 | RIVET                        |
| 11  | MS20426AD4-4 | RIVET                        |
| 4   | MS20426AD4-9 | RIVET                        |
| 4   | MS21072L06   | ANCHOR NUT                   |

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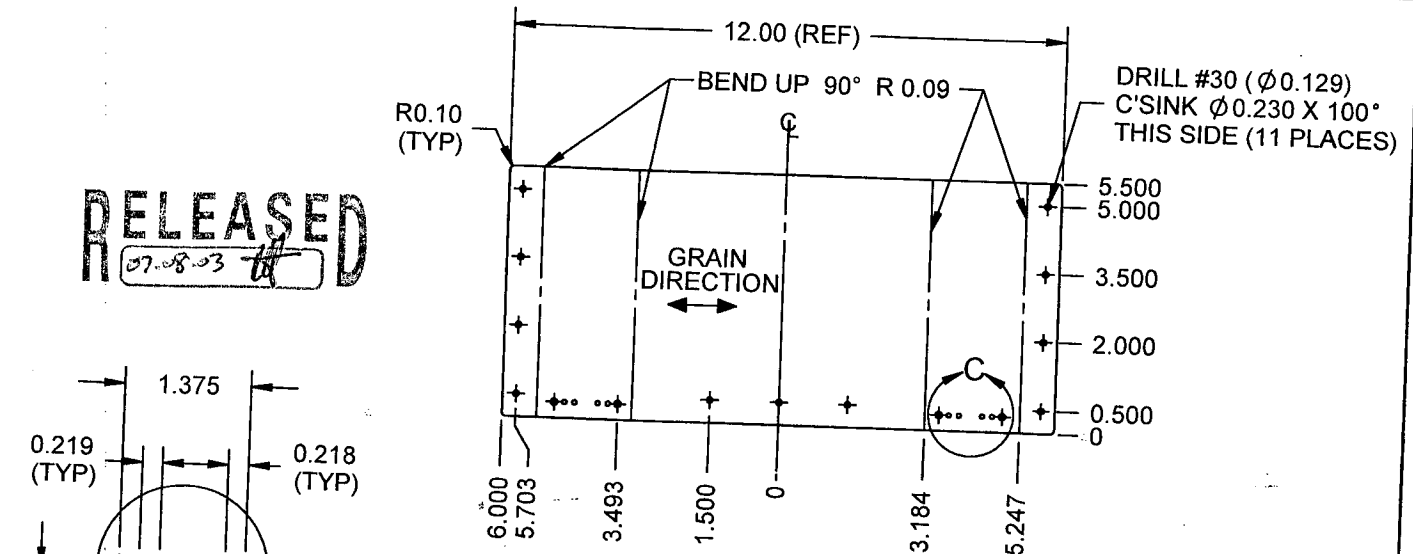
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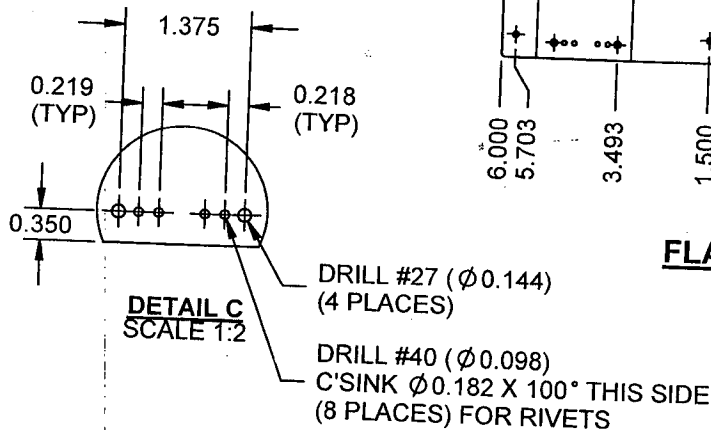
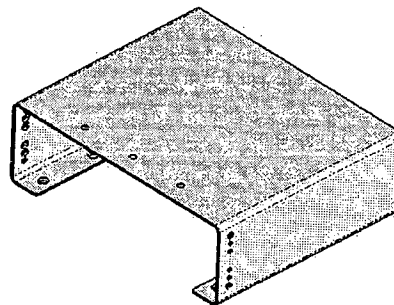


|                         |                                      |  |
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| DATE<br><b>07.06.18</b> | TITLE<br><b>GPS RECEIVER HOUSING</b> | REV. A<br>SHEET 5 OF 9<br>SCALE<br>1:4                   |

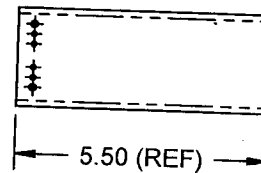
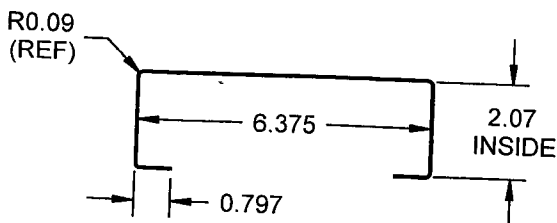
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**D3514-1F  
FLAT PATTERN**



**DETAIL C  
SCALE 1:2**



**D3514-1 BOX TOP (BOTTOM MOUNTED)**

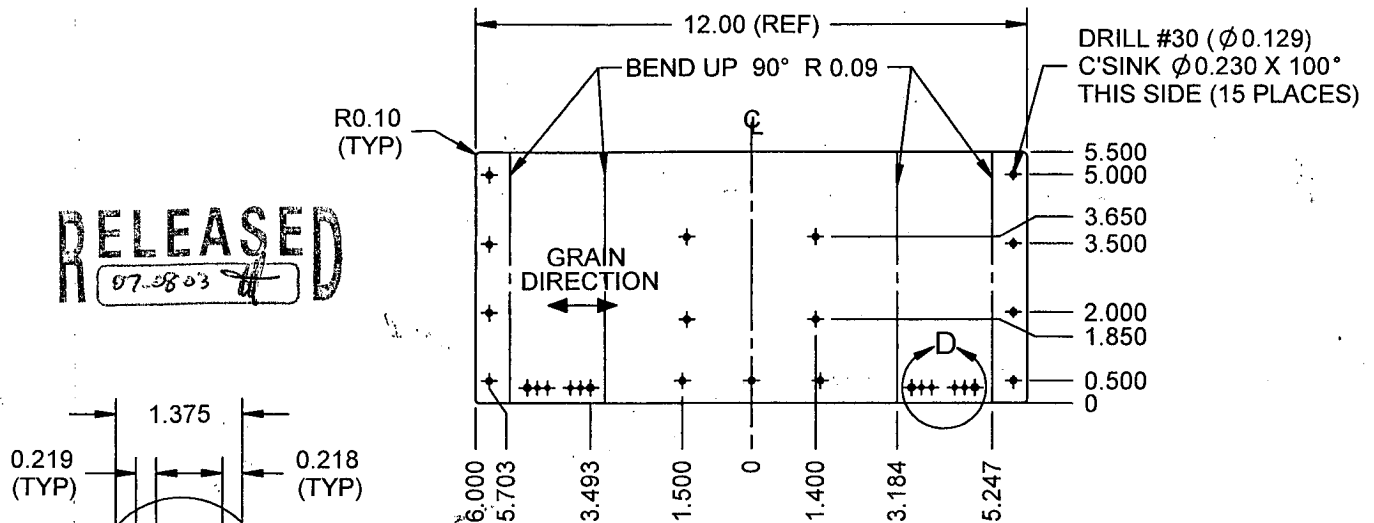
**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

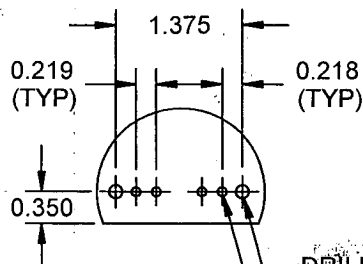
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| DATE<br>07.06.18 |                         | TITLE<br><b>GPS RECEIVER HOUSING</b>                     | SCALE<br>1:4           |



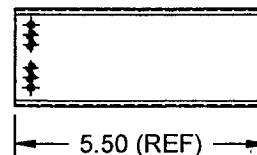
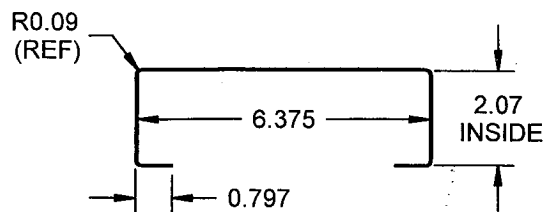
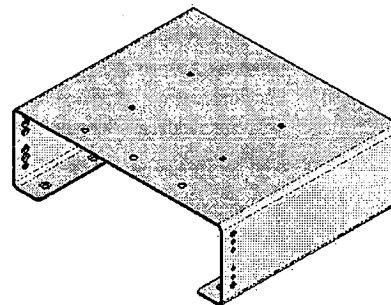
**D3514-3F  
FLAT PATTERN**



**DETAIL D  
SCALE 1:2**

DRILL #27 ( $\phi 0.144$ )  
(4 PLACES)

DRILL #40 ( $\phi 0.098$ )  
C'SINK  $\phi 0.182 \times 100^\circ$  THIS SIDE  
(8 PLACES) FOR RIVETS



**D3514-3 BOX TOP (TOP MOUNTED)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

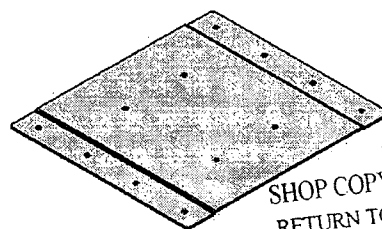
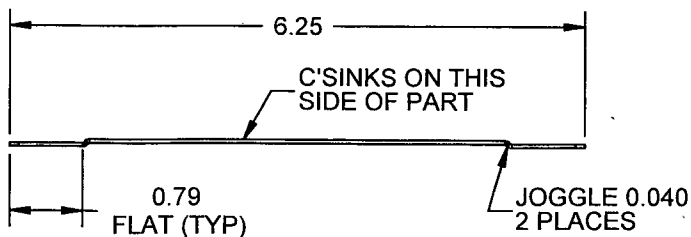
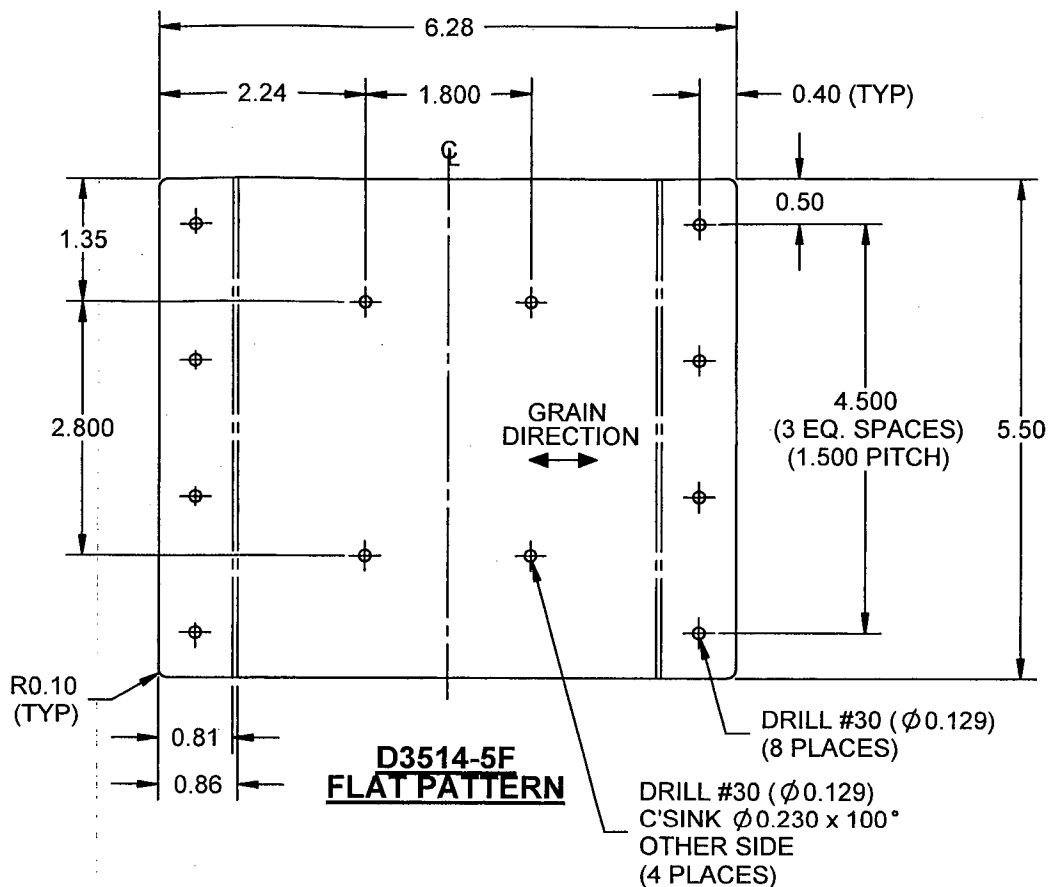
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| DATE<br><b>07.06.18</b> | TITLE<br><b>GPS RECEIVER HOUSING</b> | REV. A<br>SHEET 7 OF 9<br>SCALE<br>1:2                   |



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### D3514-5 BOX BOTTOM (BOTTOM MOUNTED)

#### NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$
- 7) C'SINK ABOVE JOGGLE

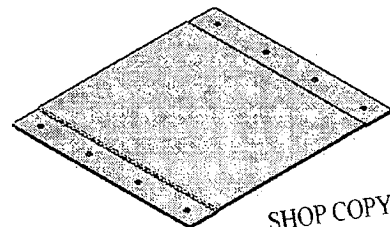
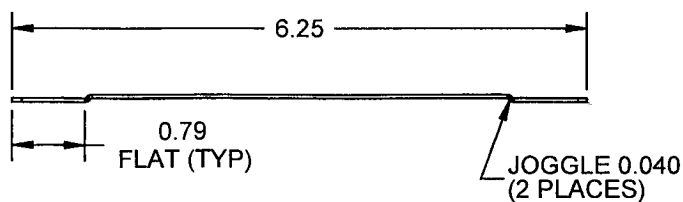
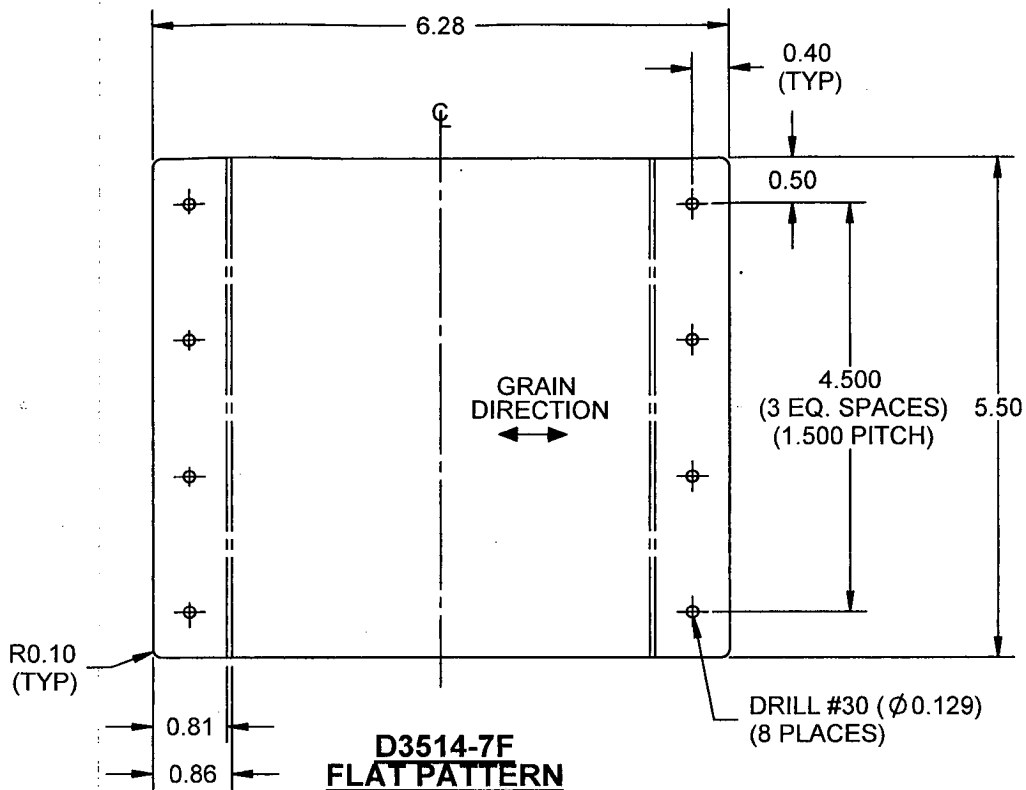
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| DESIGN<br><b>CB</b>     | DRAWN BY<br><b>CB</b>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><b>LE</b>    | APPROVED<br><b>[Signature]</b> | DRAWING NO.<br><b>D3514</b>                              | REV. A<br>SHEET 8 OF 9 |
| DATE<br><b>07.06.18</b> |                                | TITLE<br><b>GPS RECEIVER HOUSING</b>                     | SCALE<br>1:2           |



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**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

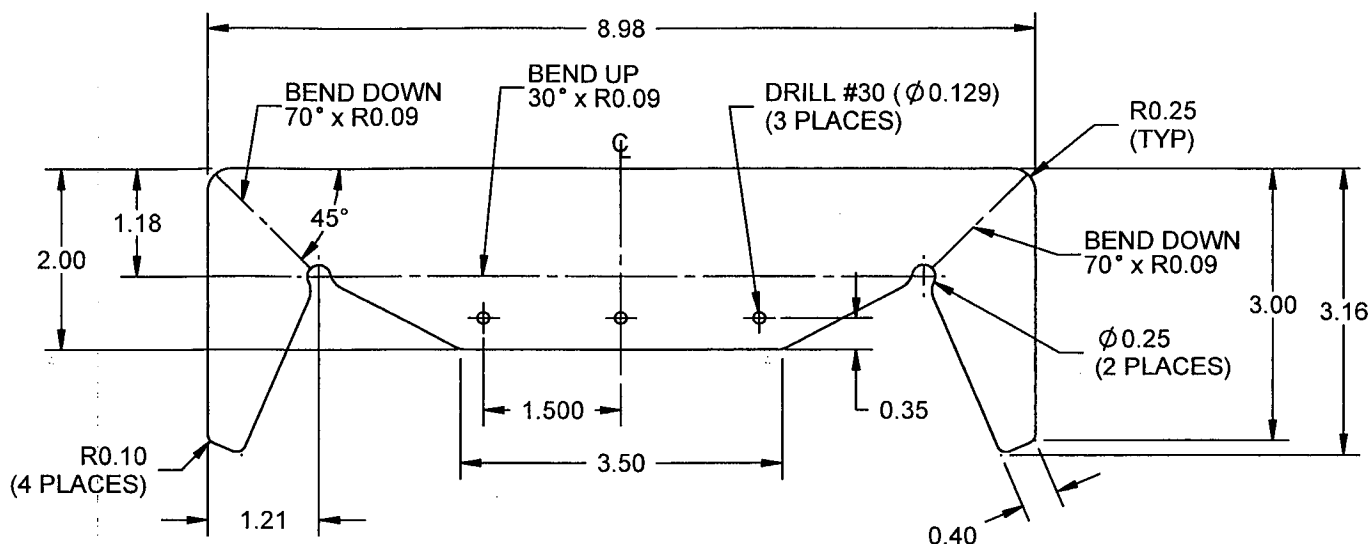
**RELEASED**  
07-08-03 **[Signature]**

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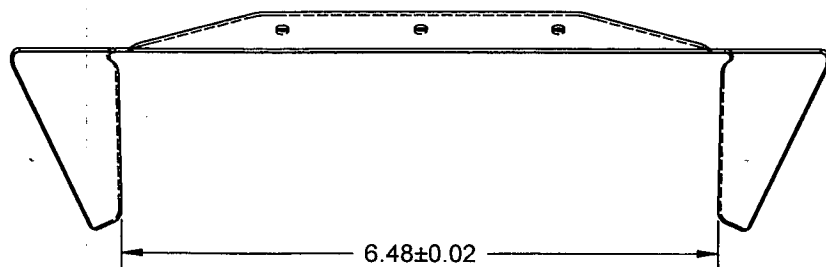
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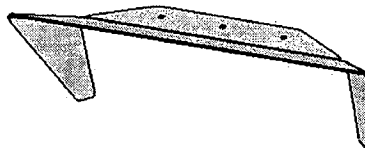
|                  |                         |   |                        |
|------------------|-------------------------|---|------------------------|
| DESIGN<br>CB     | DRAWN BY<br>CB          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>LE    | APPROVED<br>[Signature] | DRAWING NO.<br>D3514                              | REV. A<br>SHEET 9 OF 9 |
| DATE<br>07.06.18 |                         | TITLE<br>GPS RECEIVER HOUSING                     | SCALE<br>1:2           |



**D3514-9F  
FLAT PATTERN**



**FRONT VIEW**



**D3514-9 HOOD**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

**RELEASED**  
07.08.03 [Signature]

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|                                   |  |                      |
|-----------------------------------|--|----------------------|
| DART AEROSPACE LTD                |  | Work Order: 34821    |
| Description: GPS RECEIVER HOUSING |  | Part Number: D3514-3 |
| Inspection Dwg: D3514 Rev: A      |  | Page 1 of 1          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .144            | + .005 - .001 | .148             | X      |        |                      |          |
| Ø .129            | + .005 - .001 | .130             | X      |        |                      |          |
| Ø .098            | + .004 - .001 | .100             | X      |        |                      |          |
| 5.500             | +/- .010      | 5.500            | X      |        |                      |          |
| 5.000             | +/- .010      | 5.000            | X      |        |                      |          |
| 3.650             | +/- .010      | 3.650            | X      |        |                      |          |
| 3.500             | +/- .010      | 3.500            | X      |        |                      |          |
| 2.000             | +/- .010      | 2.000            | X      |        |                      |          |
| 1.850             | +/- .010      | 1.850            | X      |        |                      |          |
| .500              | +/- .010      | .500             | X      |        |                      |          |
| 12.00             | +/- .030      | 12.00            | X      |        |                      |          |
| 6.000             | +/- .010      | 6.000            | X      |        |                      |          |
| 5.703             | +/- .010      | 5.703            | X      |        |                      |          |
| 3.493             | +/- .010      | 3.493            | X      |        |                      |          |
| 1.500             | +/- .010      | 1.500            | X      |        |                      |          |
| 1.400             | +/- .010      | 1.400            | X      |        |                      |          |
| 3.184             | +/- .010      | BEND             | X      |        |                      |          |
| 5.247             | +/- .010      | BEND             | X      |        |                      |          |
| 1.375             | +/- .010      | 1.375            | X      |        |                      |          |
| .218              | +/- .010      | .218             | X      |        |                      |          |
| .219              | +/- .010      | .219             | X      |        |                      |          |
| .350              | +/- .010      | .350             | X      |        |                      |          |

|                 |                         |                     |
|-----------------|-------------------------|---------------------|
| Measured by: RB | Audited by: [Signature] | Prototype Approval: |
| Date: 07-10-2   | Date: 07/10/02          | Date:               |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |